

# Work Order ID 94457

**\*94457\***

Page 1

December-19-12 11:08:36 AM

Item ID: D4306-044

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Rib Assembly, RH

Start Date: 12/24/12 Start Qty: 1.00

Required Date: 1/11/13 Req'd Qty: 1.00

*\*1\** *(X)* *1 SCRAP*  
*\*1\** *1 GOOD*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12-12-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch M123923 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 52"
- 2- Bend tube with manuel pipe bender as per DT9567
- \*\*\* Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*
- 3- Trim access tube material to finish size and cut notch as per dwg D4306-4
- 4- Drill and chamfer holes as per dwg D4306-4 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

*(1)* *(2)* *CC 13-6-17*

*(Handwritten signature)*

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*PC 13-6-18*

*(1)* *(1)*

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: duf Date: 13/06/28QA Closed: cl Date: 13/6/21

|   |  |  |  |  |  |  |  |  |  |  |  |
|---|--|--|--|--|--|--|--|--|--|--|--|
| Work Order: <u>94457</u><br>Part No. <u>D4306-044</u><br>NCR No. <u>13-2262</u> |  |  |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input checked="" type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |  |  |  |  |  |
|---|--|--|--|--|--|--|--|--|--|--|--|

| Root Cause  | Date           | Step       | Qty       | Description of work order update or Non-conformance                   | Initial Chief Eng               | Action Description  | Sign & Date                 | Verification   | QC Inspector  |
|---|----------------|------------|-----------|---|---------------------------------|---|-----------------------------|--|---|
| Doc/Data <input type="checkbox"/><br>Equip/Tooling <input checked="" type="checkbox"/><br>Operator <input type="checkbox"/><br>Material <input type="checkbox"/><br>Setup <input type="checkbox"/><br>Other <input type="checkbox"/><br>Process <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Unapproved <input type="checkbox"/> | <u>13/6/17</u> | <u>100</u> | <u>x1</u> | <u>Rig was drilled at wrong dim.</u><br><u>bc poor / Lack of bolu</u> | <u>Q52042</u><br><u>13/6/17</u> | <u>Scrap + Destroy</u><br><u>FIXED PROBLEM</u><br><u>SCRAPP + DESTROY</u><br><u>(QTY 1)</u> | <u>CC</u><br><u>13-6-18</u> | <u>CPL</u><br><u>13-6-18</u><br><u>(DAS 24 9-88)</u> | <u>Q52042</u><br><u>13/6/17</u><br><u>(DAS 16 9-88)</u> |

| FAULT CATEGORY  |   |   |   |
|---|---|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |

# Work Order ID 94457

\*94457\*

Page 2

December-19-12 11:08:36 AM

Item ID: D4306-044

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly, RH

Start Date: 12/24/12 Start Qty: 1.00

\*1\* (2)  
\*1\*

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

PC 13.6.18

(1)

(1)

\*120\*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: WAH

0.00

PC 13.6.18

(1) Good

(1) SCRAP

\*130\*

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

13/6/19

\*140\*

QC

Memo

0.00

Quality Control

MFC

13-6-18

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                      |   |                |              |   |  |  |
|---|------|------|---|---|----------------------|---|----------------|--------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                |              |   |  |  |
| <b>Root Cause</b>   | Date | Step | Qty   | Description of work order update<br>or Non-conformance  | Initial<br>Chief Eng | Action<br>Description   | Sign &<br>Date | Verification | QC Inspector  |  |  |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Operator <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Material <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Setup <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Other <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Process <input type="checkbox"/>  |      |      |   |   |                      |   |                |              |   |  |  |
| Supplier <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Training <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                      |   |                |              |   |  |  |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                      |   |                |              |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                      | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |                |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |  |  |

# Picklist Print

December-19-12 11:08:36 AM

Page 1

Work Order ID: 94457  
Parent Item: D4306-044  
Parent Item Name: Rib Assembly, RH

Start Date: 12/24/12 Required Date: 1/11/13  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC IPP Rev:B 11.03.03 AS PER  
DWG REV.C DD verf:EC

| Component Item ID/<br>Item Name               | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3759-1<br>Bushing                            |                        | Manufactured  | No          |                     |                  | 100             | Each               | 246.0000       | 4           | 4            |               | CC 13-6-17     |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | WA004               |                  | 246             | B98756 →           |                |             |              |               |                |        |
|   |                        |               |             | 66489               |                  | 1               |                    |                |             |              |               |                |        |
|   |                        |               |             | 79213               |                  | 1               |                    |                |             |              |               |                |        |
|   |                        |               |             | 83464               |                  | 7               |                    |                |             |              |               |                |        |
|   |                        |               |             | 86550               |                  | 20              |                    |                |             |              |               |                |        |
|   |                        |               |             | 89780               |                  | 11              |                    |                |             |              |               |                |        |
|   |                        |               |             | 90786               |                  | 206             |                    |                |             |              |               |                |        |
| M304TS0.750W.049<br>304 SQ Tube .75x.75x.049W |                        | Purchased     | No          |                     |                  | 100             | f                  | 905.1312       | 4.166       | 4.3852632    |               | CC 13-6-17     |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|   |                        |               |             | MAT017              |                  | 2.0156214       |                    |                |             |              |               |                |        |
|   |                        |               |             | 121898              |                  | 2.0156214       |                    |                |             |              |               |                |        |
|   |                        |               |             | WA006               |                  | 903.1155859     |                    |                |             |              |               |                |        |
|   |                        |               |             | 122201              |                  | 0.1626          |                    |                |             |              |               |                |        |
|   |                        |               |             | 122425              |                  | 39.0000000      |                    |                |             |              |               |                |        |
|   |                        |               |             | 122666              |                  | 0.7293          |                    |                |             |              |               |                |        |
|   |                        |               |             | 122710              |                  | 20.5            |                    |                |             |              |               |                |        |
|   |                        |               |             | 123219              |                  | 289.5           |                    |                |             |              |               |                |        |
|   |                        |               |             | 123484              |                  | 553.223686      |                    |                |             |              |               |                |        |

M125575 → 8.7705264

NCR: Yes / No

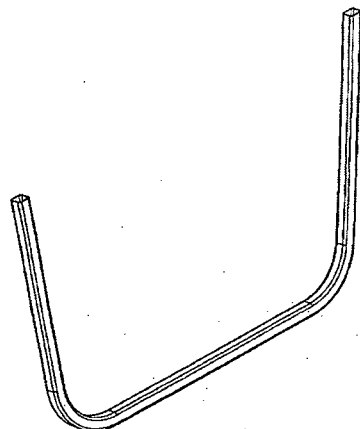
**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

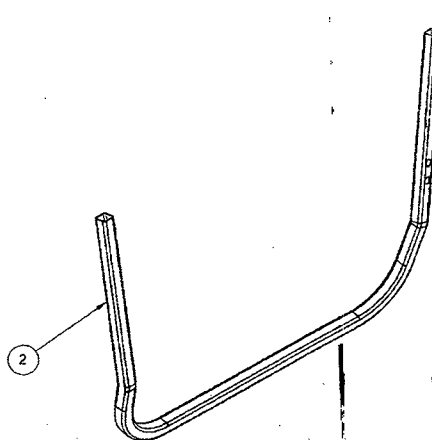
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|   |      |      |   |   |                   |   |             |              |   |  |  |
|---|------|------|---|---|-------------------|---|-------------|--------------|---|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____  |      |      |   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |   |  |  |
| Root Cause  | Date | Step | Qty   | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector  |  |  |
| Doc/Data <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Equip/Tooling <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Operator <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Material <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Setup <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Other <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Process <input type="checkbox"/>  |      |      |   |   |                   |   |             |              |   |  |  |
| Supplier <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Training <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| Unapproved <input type="checkbox"/>   |      |      |   |   |                   |   |             |              |   |  |  |
| <b>FAULT CATEGORY</b>   |      |      |   |   |                   |   |             |              |   |  |  |
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube |      |      | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio |   |                   | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions   |             |              | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |  |  |

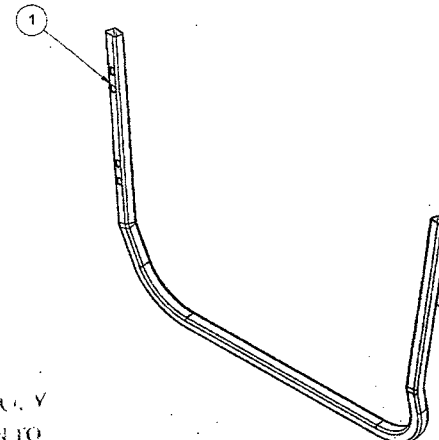
| ITEM | QTY<br>-043 | QTY<br>-044 | QTY<br>-045 | P/N       | DESCRIPTION  |
|------|-------------|-------------|-------------|-----------|--------------|
|      | X           |             |             | D4306-043 | RIB ASSY, LH |
|      |             | X           |             | D4306-044 | RIB ASSY, RH |
|      |             |             | X           | D4306-045 | RIB ASSY     |
| 1    | 4           | 4           | 4           | D3759-1   | BUSHING      |
| 2    | 1           |             |             | D4306-3   | RIB          |
| 3    |             | 1           |             | D4306-4   | RIB          |
| 4    |             |             | 1           | D4306-5   | RIB          |



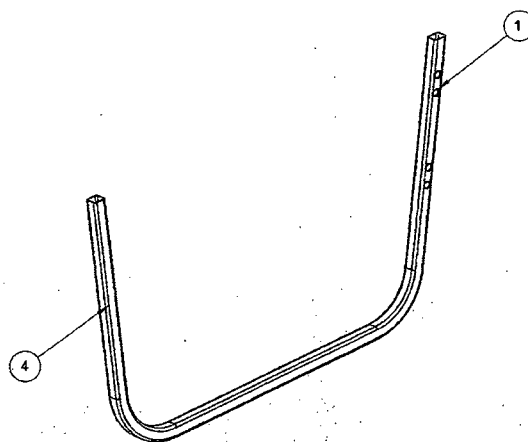
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**



**D4306-045 RIB ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 94457 MLO  
12-12-09

**RELEASED**  
2011-03-18

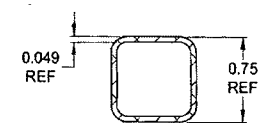
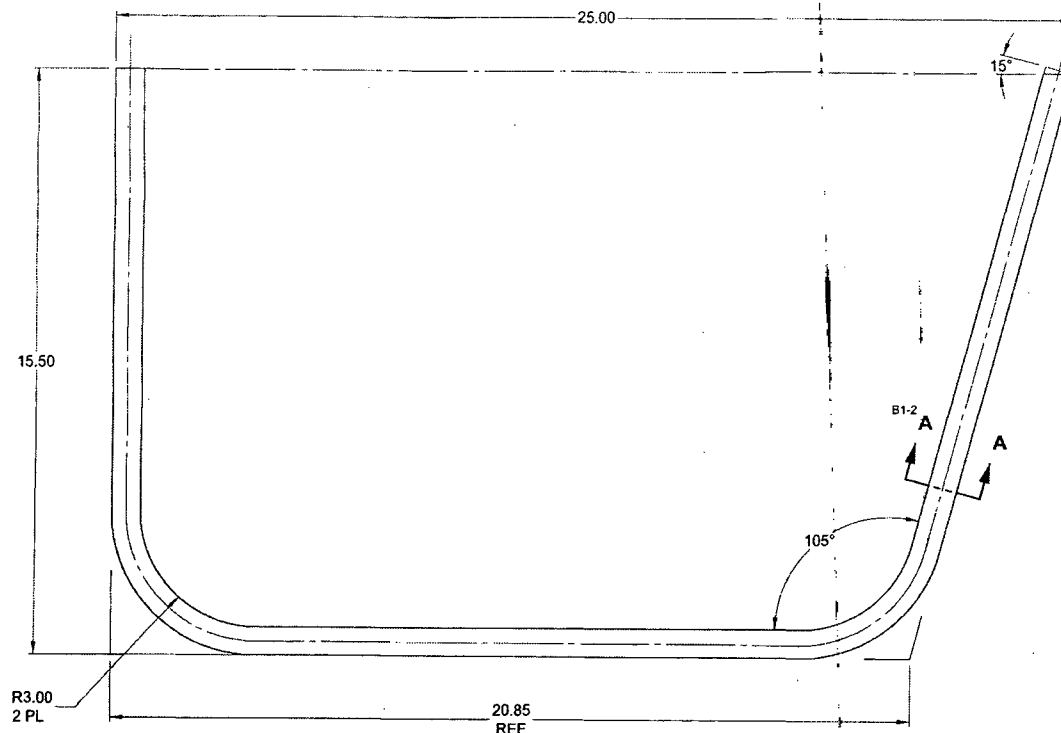
| C          | REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4/6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5) | SC | 11.02.09 |
|------------|--|----|----------|
| B          | D4306-043, D4306-044, D4306-045 ADDED  | SC | 10.12.17 |
| A          | NEW ISSUE  | CP | 10.11.29 |
| REV.       | DESCRIPTION  | BY | DATE     |
| DESIGN     | CP   |    |          |
| DRAWN      | SC   |    |          |
| CHECKED    |  |    |          |
| MFG. APPR. |  |    |          |
| APPROVED   |  |    |          |
| DE APPR.   |  |    |          |
| DATE       | 11.02.09   |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4306** REV. C  
SHEET 1 OF 8  
TITLE **RIB** SCALE NTS

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94457



SECTION A-A  
B4-2

8 D4306-1 RIB

RELEASED  
2011-02-24  
WJD

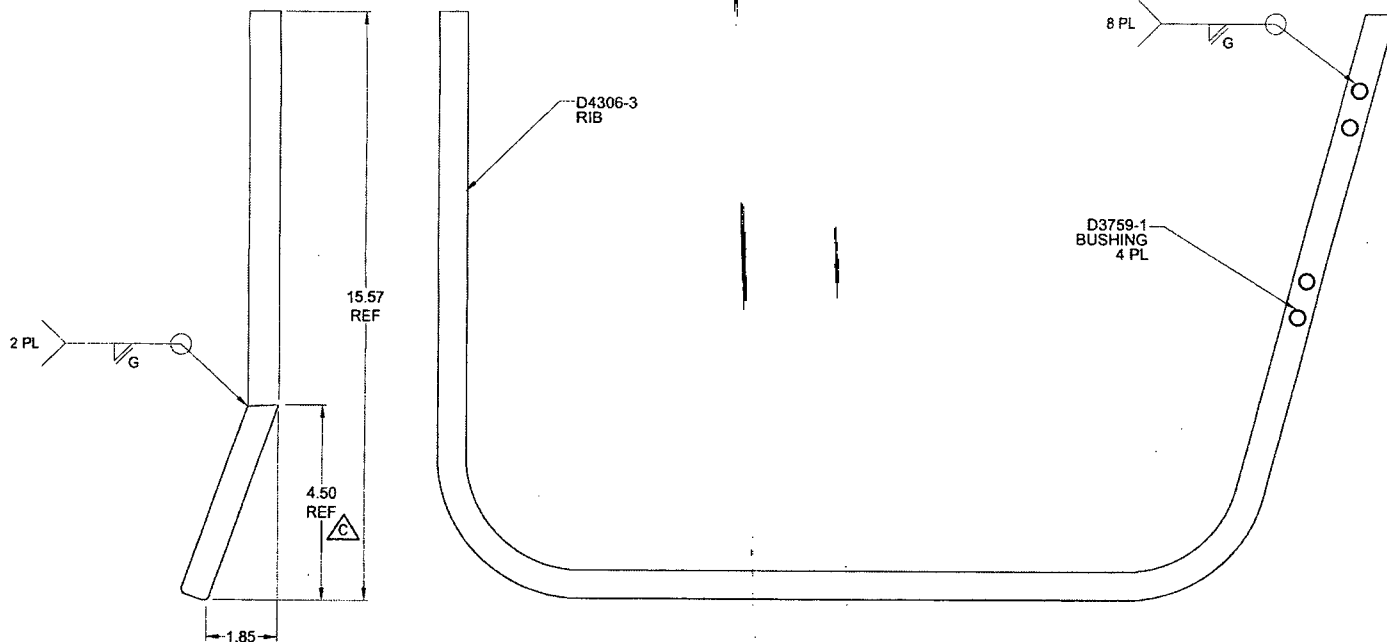
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

|            |          |  |                        |
|------------|----------|--|------------------------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |                        |
| DRAWN      | SC       |  |                        |
| CHECKED    |          | DRAWING NO.<br><b>D4306</b>  | REV. C<br>SHEET 2 OF 8 |
| MFG. APPR. |          | TITLE<br><b>RIB</b>  | SCALE<br>NTS           |
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| DE APPR.   |          |  |                        |
| DATE       | 11.02.09 |  |                        |



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**D4306-043 RIB ASSY, LH**

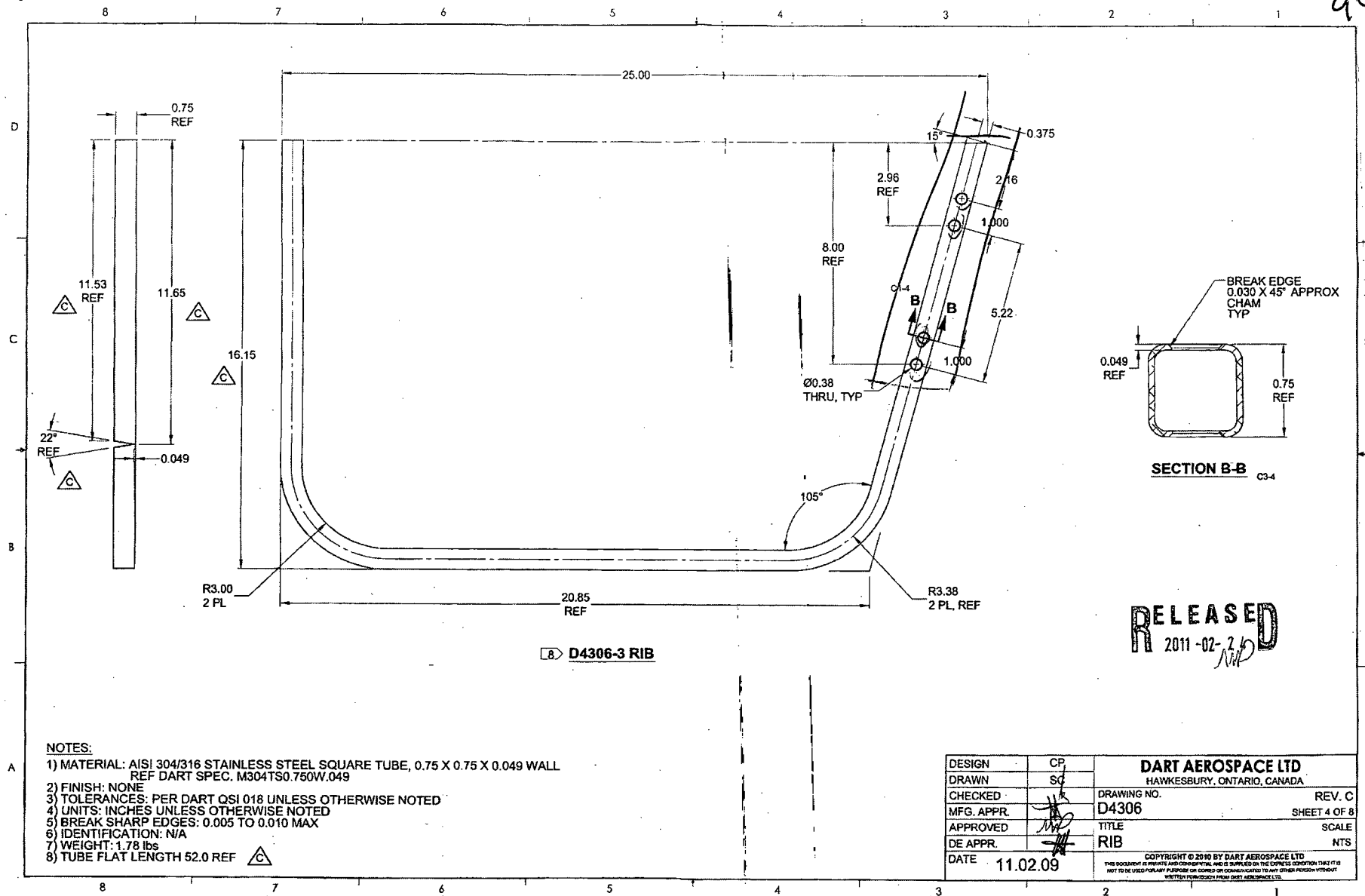
RELEASED  
2011-02-24  
MD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

|            |          |   |        |
|------------|----------|---|--------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |        |
| DRAWN      | SC       |   |        |
| CHECKED    | AS       | DRAWING NO.<br><b>D4306</b>   | REV. C |
| MFG. APPR. | AS       | SHEET 3 OF 8  |        |
| APPROVED   | AS       | TITLE   | SCALE  |
| DE APPR.   | AS       | RIB   | NTS    |
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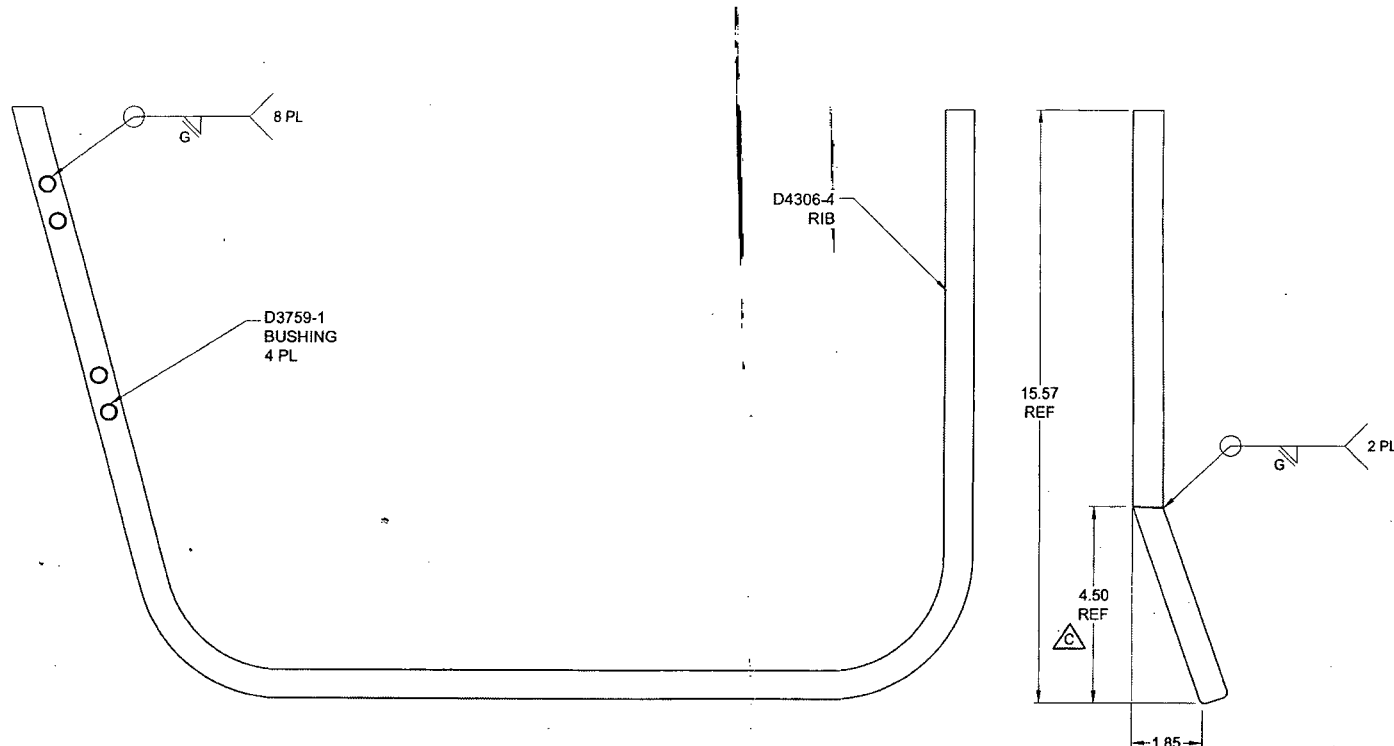
RELEASED  
2011-02-20

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750V.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | CP       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | SG       |   |              |
| CHECKED    |          | DRAWING NO.   | REV. C       |
| MFG. APPR. |          | D4306   | SHEET 4 OF 8 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | RIB   | NTS          |
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**D4306-044 RIB ASSY, RH**

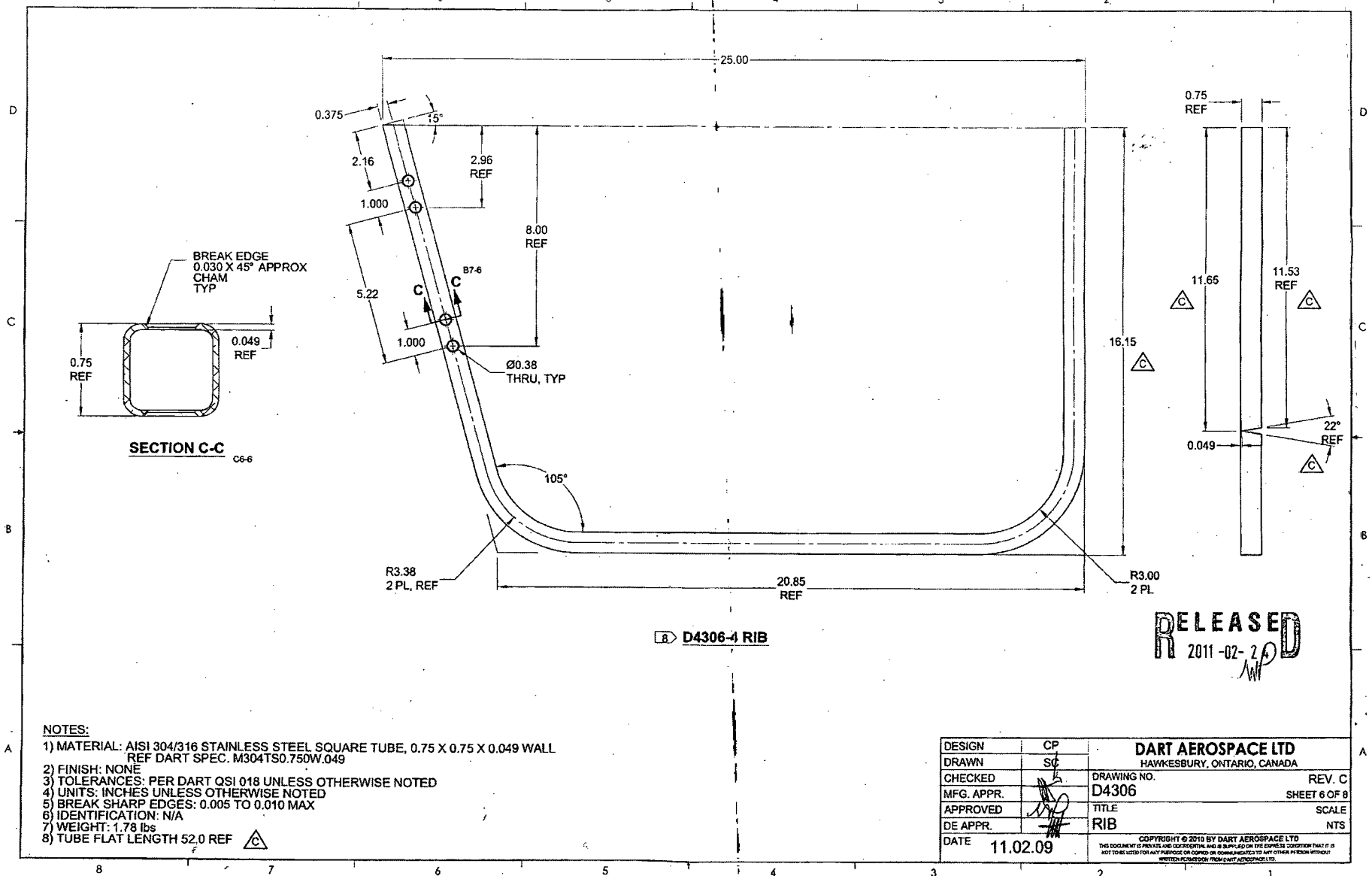
**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | SC       |  |              |
| CHECKED    | JS       | DRAWING NO.  | REV. C       |
| MFG. APPR. | JS       | <b>D4306</b>   | SHEET 5 OF 8 |
| APPROVED   | JS       | TITLE  | SCALE        |
| DE APPR.   | JS       | <b>RIB</b>   | NTS          |
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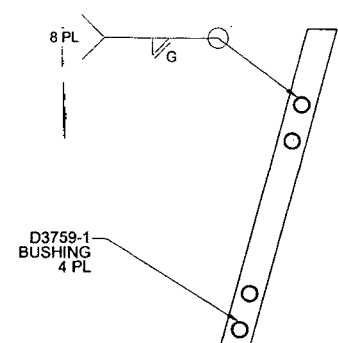


**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | SC       |  |              |
| CHECKED    |          | DRAWING NO.<br><b>D4306</b>  | REV. C       |
| MFG. APPR. |          |  | SHEET 6 OF 8 |
| APPROVED   |          | TITLE<br><b>RIB</b>  | SCALE<br>NTS |
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| DATE       | 11.02.09 |  |              |

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**D4306-045 RIB ASSY**

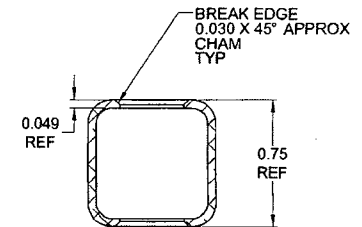
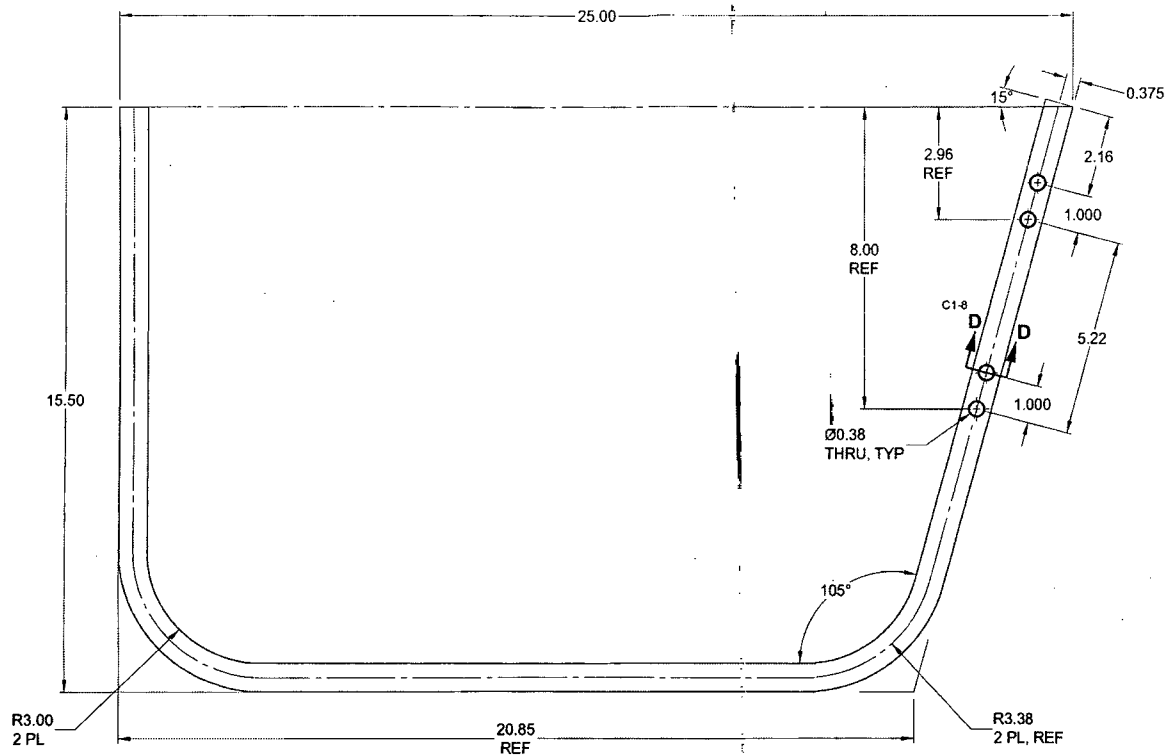
RELEASED  
2011-02-24  
MAD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CP       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | SC       |  |              |
| CHECKED    | W        | DRAWING NO.  | REV. C       |
| MFG. APPR. | W        | <b>D4306</b>   | SHEET 7 OF 8 |
| APPROVED   | W        | TITLE  | SCALE        |
| DE APPR.   | W        | <b>RIB</b>   | NTS          |
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SECTION D-D C3-8

B D4306-5 RIB

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2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CP       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | SC       |  |              |
| CHECKED    | LS       | DRAWING NO.<br>D4306   | REV. C       |
| MFG. APPR. |          |  | SHEET 8 OF 8 |
| APPROVED   |          | TITLE<br>RIB   | SCALE        |
| DE APPR.   |          |  | NTS          |
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